

Date: Monday, 1/7/2008 3:38:31 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BRACKET ASSEMBLY		
Job Number	36630					
Estimate Number	10279					
P.O. Number	:		Part Number	D3121143		
This Issue	1/7/2008	S.O. No. :	Drawing Number	D3121 REV E		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type : MACHINED PARTS	Drawing Revision	E		
Previous Run	31728		Material	:		
Written By	:		Due Date	1/31/2008	Qty:	8 Um: Each
Checked & Approved By	:					
Comment	Est Rev: Pick:A 04.02.18 New issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M174B1000X02000	17-4 SS Bar	
		Comment: Qty.: 0.3864 f(s)/Unit Total : 3.0912 f(s) Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.000x02.000) Identify for D3121-113 Batch: M102741	J.L 08/01/14
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: (1.000" x 2.000") 4.425" long	J.L 08/01/14
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1  1-Machine D3121-113 as per Folio FA330 and Dwg D3121 Identify as D3121-113  2-Deburr  3-Scribe batch number	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/01/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.01.24	3.0	0.160 is 0.140 (0.010 out of tolerance) 1 part	VE 08.01.24	Acceptable	ML 08/01/25	VE 08/01/25	VE 08.01.24	VE 08.01.24

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:31 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 36630

Part Number: D3121143

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*3C 08/01/25*

(8)

6.0 D312121 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3121-21 Bolt *B36608X12*

*B36668X4*

*mk 08/01/25*

(8)

7.0 D3121241 Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

*NO IN COMPUTER*

Pick:

Qty Part Number Description Batch

2 D3121-241 Bearing Ass *B36669*

*mk 08/01/25*

(8)

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-143 as per Dwg D3121.

*mk 08/01/25*

(8)

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*3C 08/01/25*

(8)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST233*

*PC 08/01/25*

(8)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*ND 08/01/09*

(8)

Job Completion



*2008/11/28*

*W*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36630
Description: Bracket	Part Number:	D3121-113
Inspection Dwg: D3121 Rev: D/E		Page 1 of 2

**FIRST ARTICLE INSPECTION CHECKLIST**

08.01.08       First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	0.083	/			
0.300	+/-0.010	0.304	/			
R0.375	+/-0.010	R0.375	/			
1.54	+/-0.030	1.540	/			
0.350	+/-0.010	0.353	/			
R0.250	+/-0.010	R0.250	/			
1.000	+/-0.050					
Ø0.392	+0.002/-0.000	Ø0.393	/			
Ø0.201	+0.005/-0.000	Ø0.201	/			
0.100	+/-0.010	0.097	/			
2.540	+/-0.010	2.539	/			
1.590	+/-0.010	1.589	/			
0.160	+/-0.010	0.159	/			
0.400	+/-0.010	0.397	/			
1.220	+/-0.010	1.217	/			
1.600	+/-0.010	1.601	/			
3.80	+/-0.030	3.800	/			
1.800	+/-0.010	1.801	/			
R0.500	+/-0.030	R0.500	/			
0.130	+/-0.010	0.128	/			
3.41	+/-0.030	3.410	/			
3.65	+/-0.030	3.631	/			
2.24	+/-0.030	2.210	/			
45°	+/-1°	45°	/			
R0.250	+/-0.030	R0.250	/			
3.97	+/-0.030	3.964	/			
R0.38	+/-0.030	R0.380	/			
Ø0.392	+0.002/-0.000	Ø0.3936	/			
Ø0.201	+0.005/-0.000	Ø0.201	/			
0.100	+/-0.010					
0.268	+/-0.010	0.268	/			
R0.260	+/-0.010	R0.260	/			
0.080	+/-0.010	0.082	/			
0.300	+/-0.010	0.303	/			



DART AEROSPACE LTD	Work Order:	36630
Description: Bracket	Part Number:	D3121-113
Inspection Dwg: D3121 Rev: D/E		Page 2 of 2

# FIRST ARTICLE INSPECTION CHECKLIST

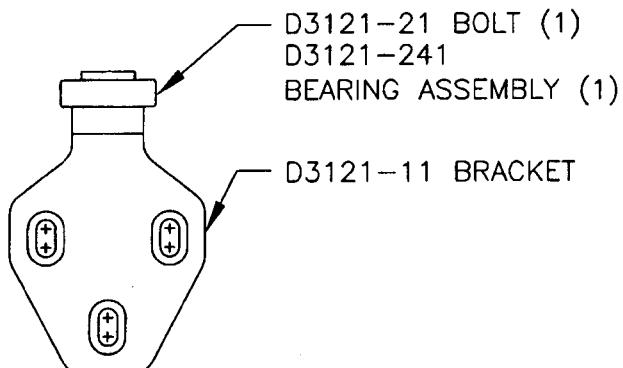
## X First Article      Prototype

Measured by:	<u>ZuQ</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	08/01/24	Date:	08.01.24	Date:	N/A

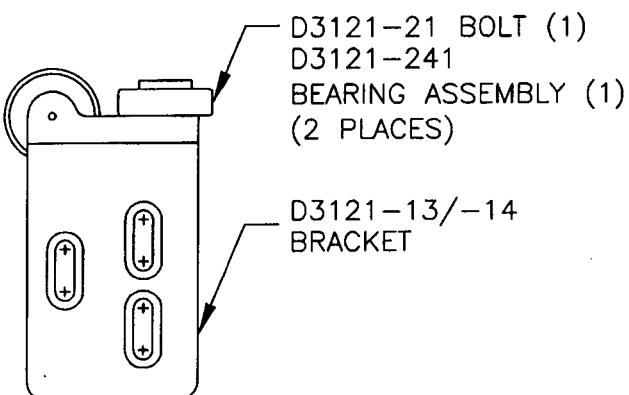
Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue P/O D3121-143	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	✓ ✓

**DART**

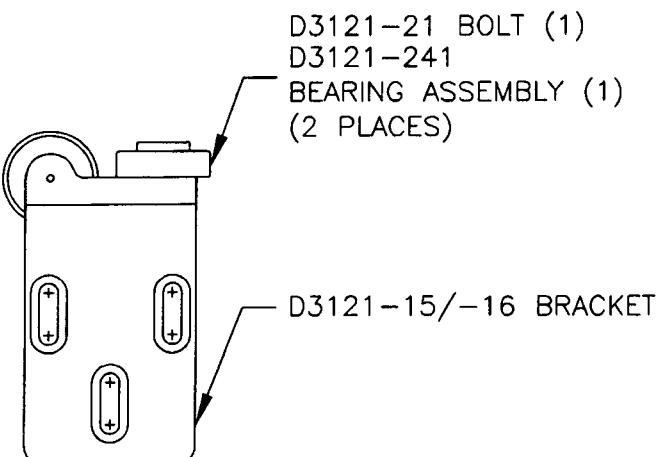
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

**RELEASED**  
07.11.07 *WJD***D3121-041 BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-33)

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)  
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-37/-38)

**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)  
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-35/-36)

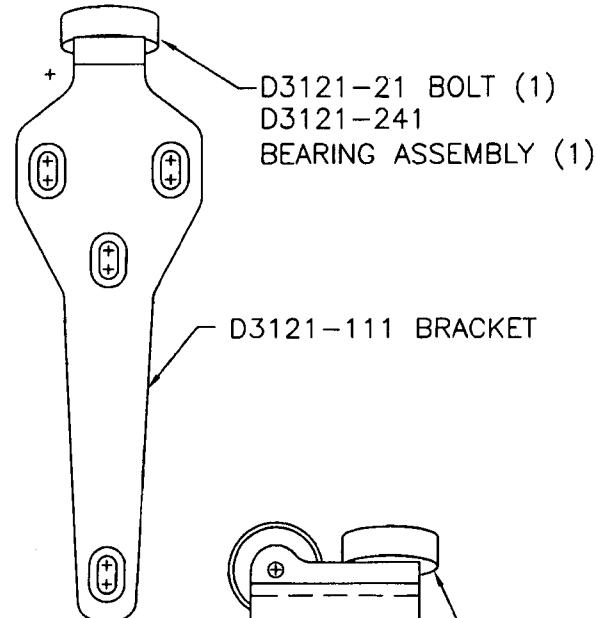
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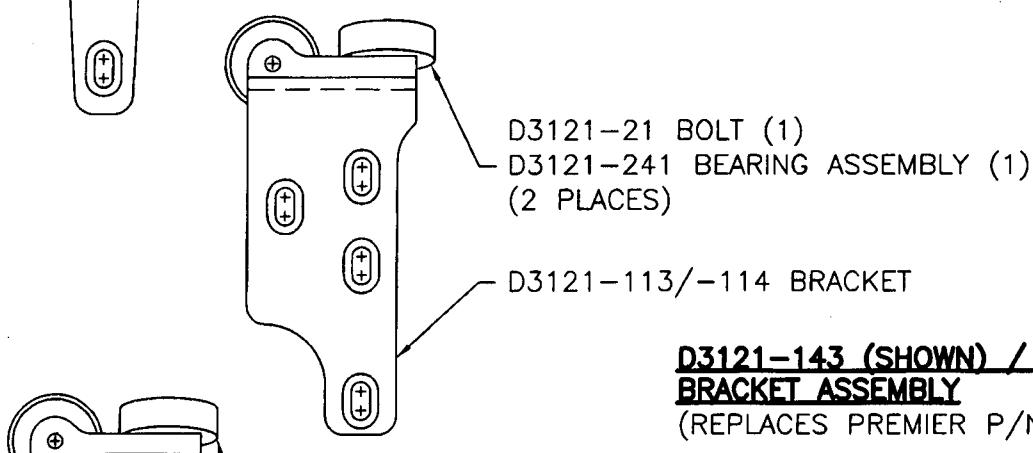
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

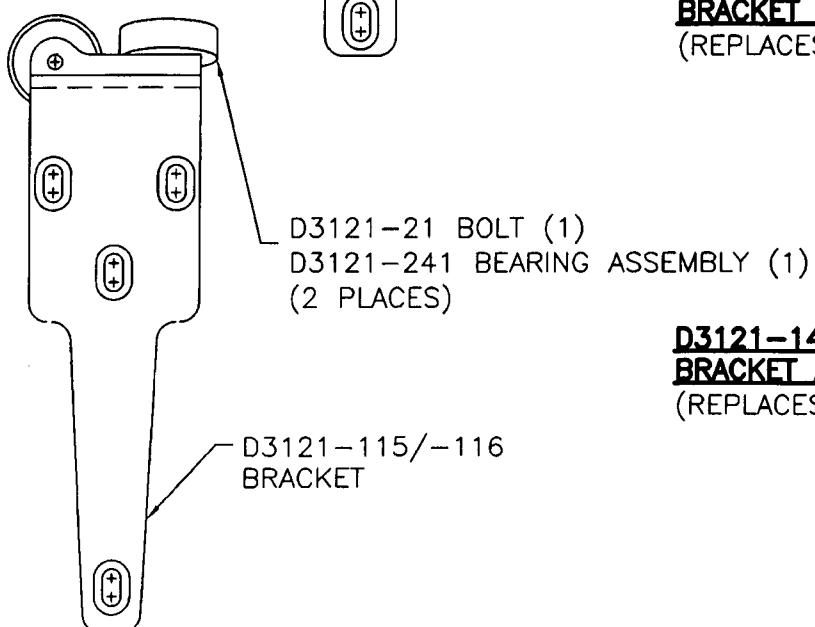


**D3121-141 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23001-01)

**RELEASED**  
07.11.07 *W*



**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-03/-04)



**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-05/-06)

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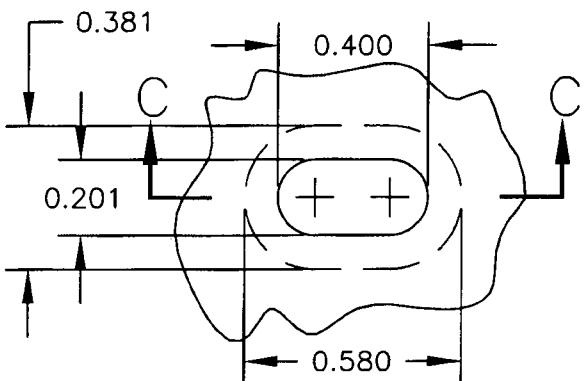
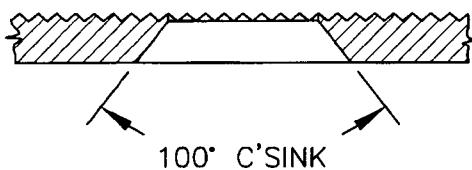
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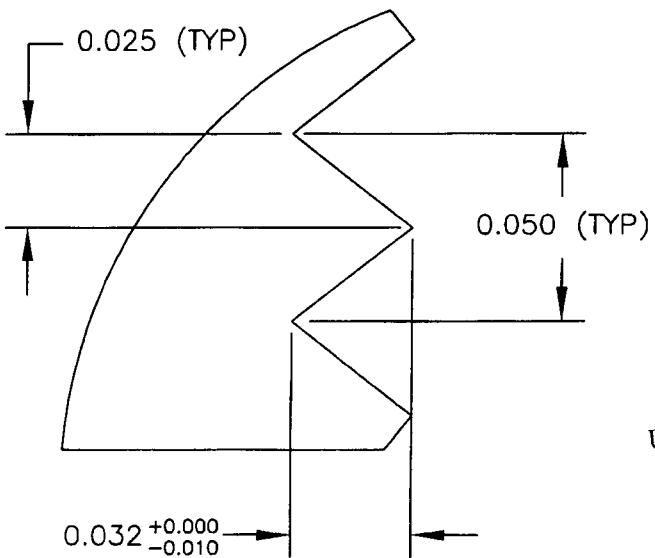
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**DETAIL A:**  
**SLOT DETAIL**  
SCALE 2:1  
VIEW ROTATED

**SECTION  
C-C****RELEASED**  
07.11.07 *[Signature]*

**DETAIL B:**  
**RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20



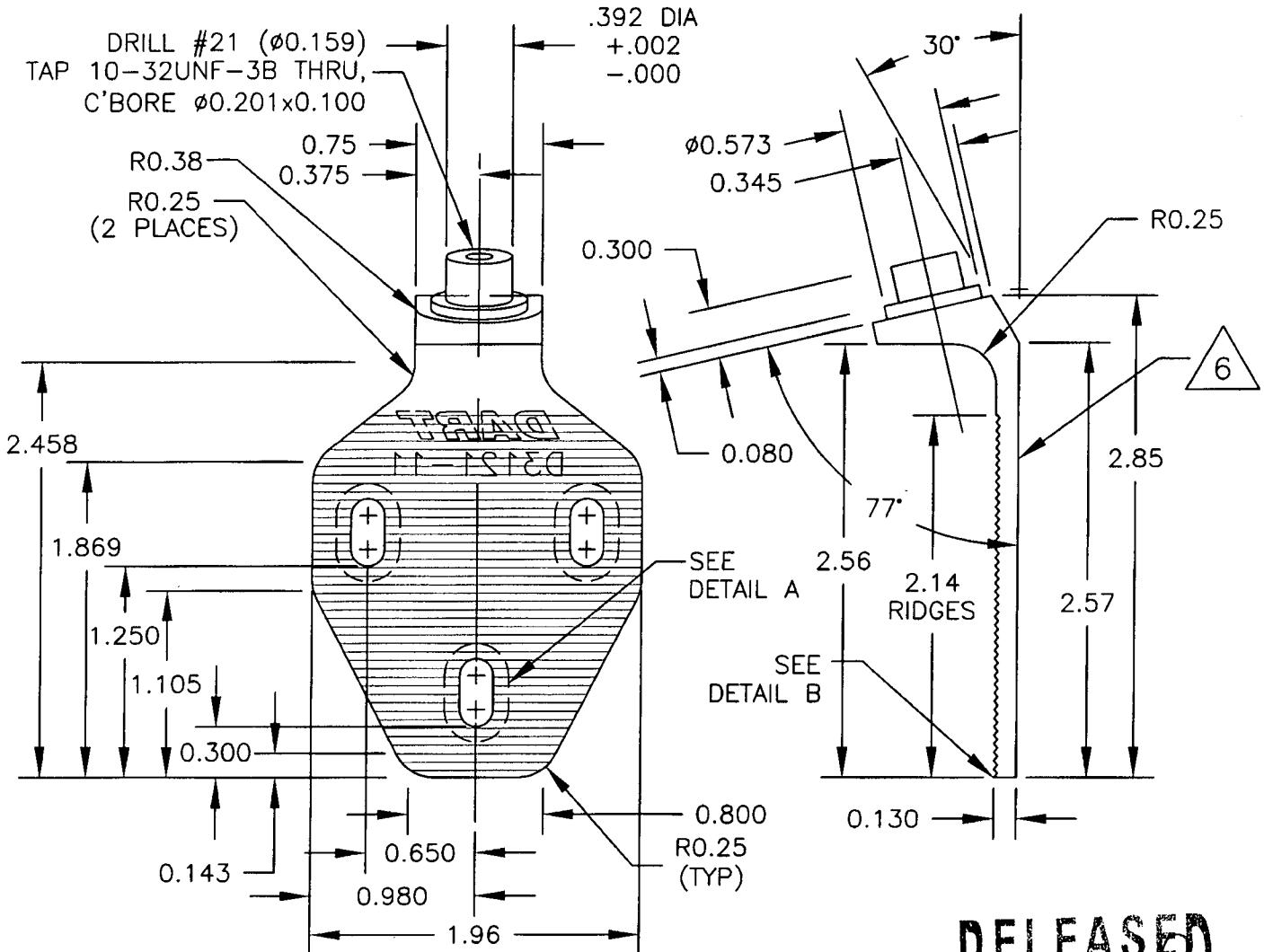
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CHECKED 	APPROVED 	DRAWING NO. D3121	REV. E	SHEET 4 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1	



RELEASED  
07.11.07 MP

D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

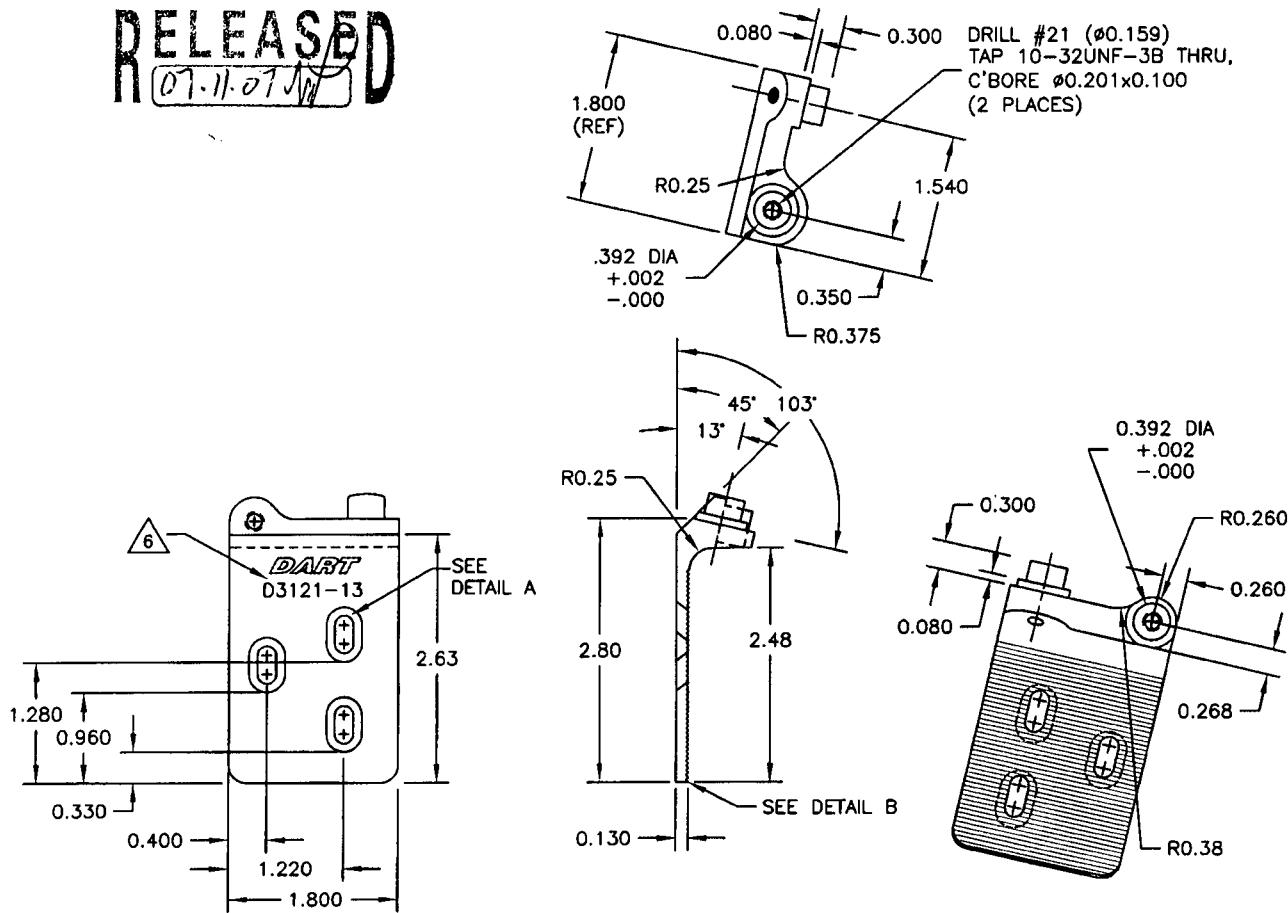
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3121	REV. E SHEET 5 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

**RELEASED**  
*(07.11.07)***D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

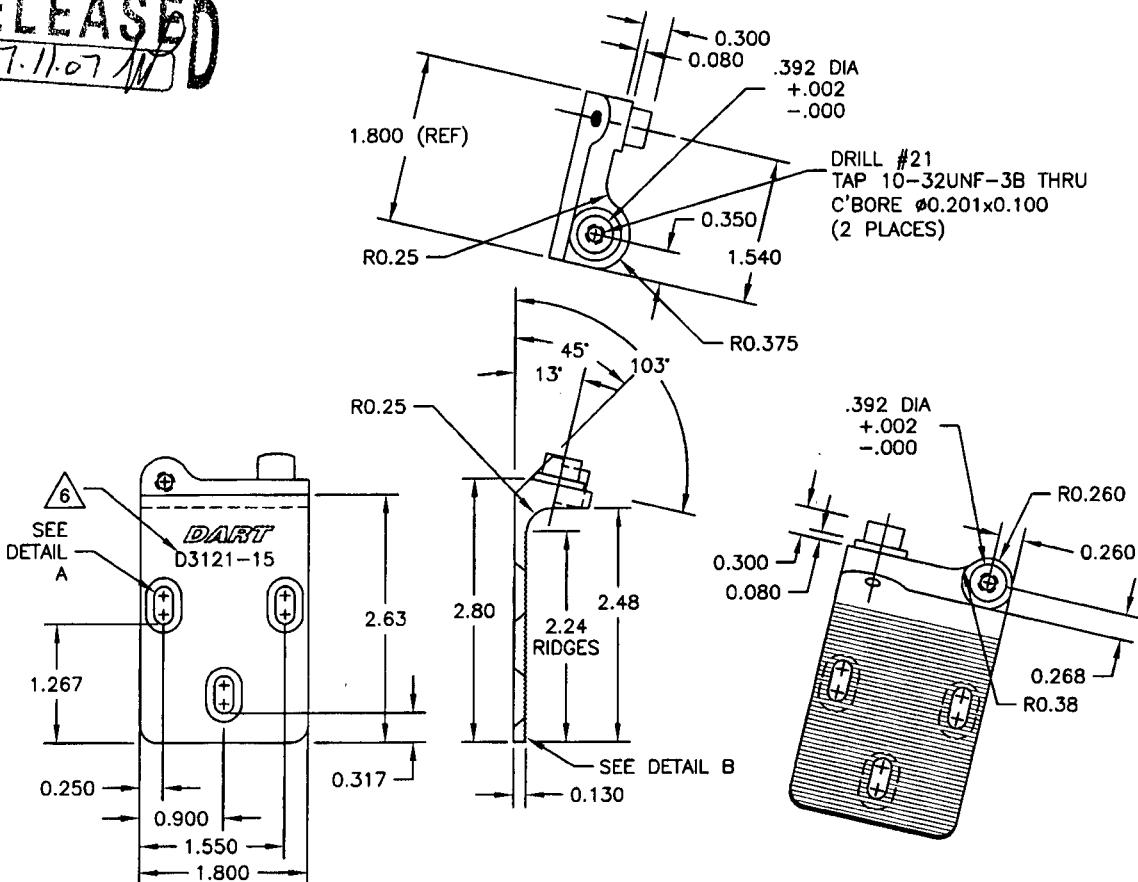
1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
 MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
 MIN YIELD TENSILE STRENGTH = 100 ksi

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 3) ALL DIMENSIONS ARE IN INCHES  
 4) BREAK ALL SHARP EDGES 0.005 TO 0.015  
 5) ENGRAVE DART P/N & LOGO AS SHOWN  
 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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 NO. *36630*

**DART**

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CHECKED	APPROVED	DRAWING NO. D3121 REV. E
DATE 07.11.07		SHEET 6 OF 10 TITLE SCALE 1:2 BRACKET ASSEMBLY

**RELEASED**  
07.11.07

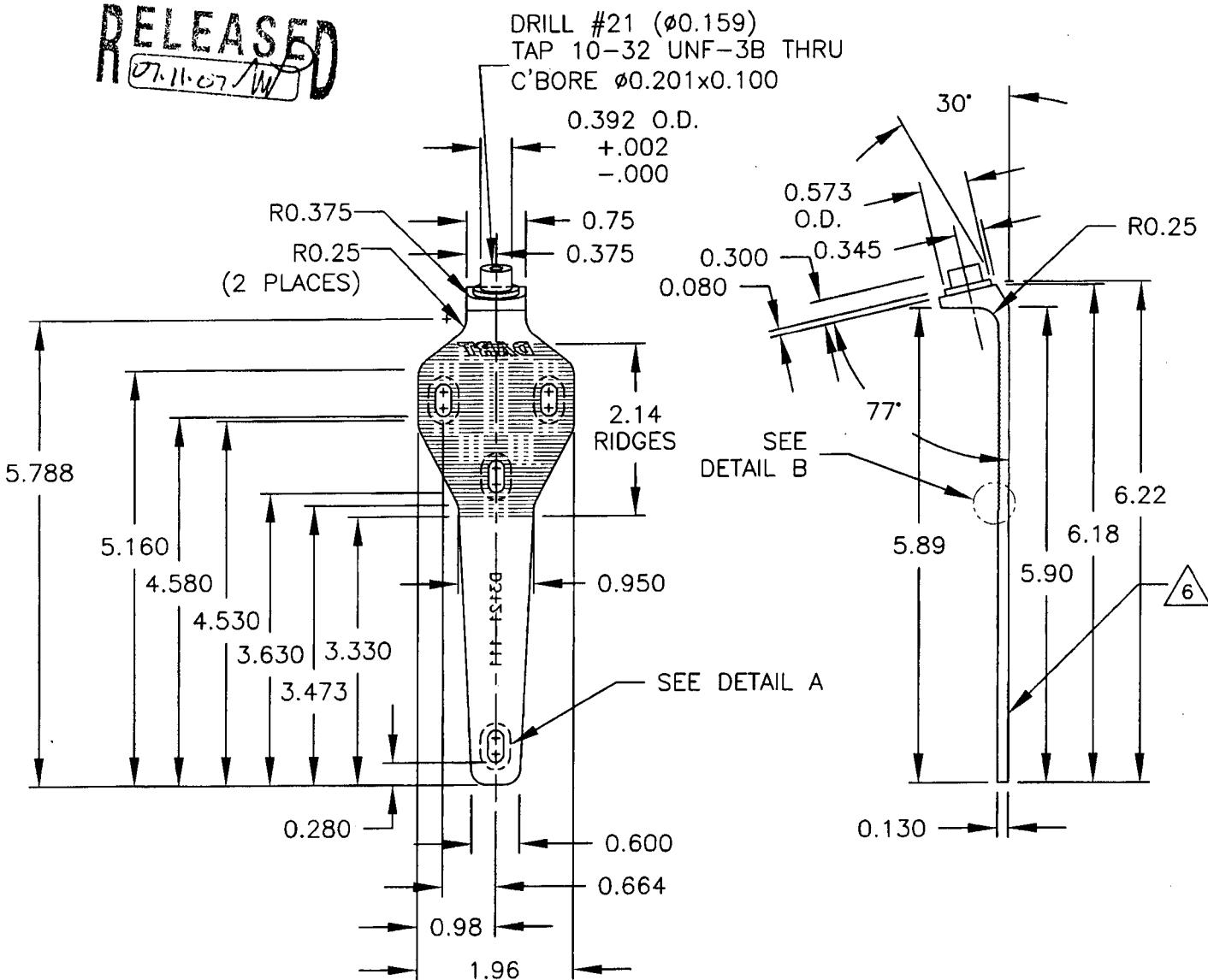
**D3121-15 BRACKET (SHOWN)**  
**D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
 MIN ULTIMATE TENSILE = 150 ksi  
 MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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**DART**

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DATE		REV. E SHEET 7 OF 10 TITLE SCALE BRACKET ASSEMBLY 1:2

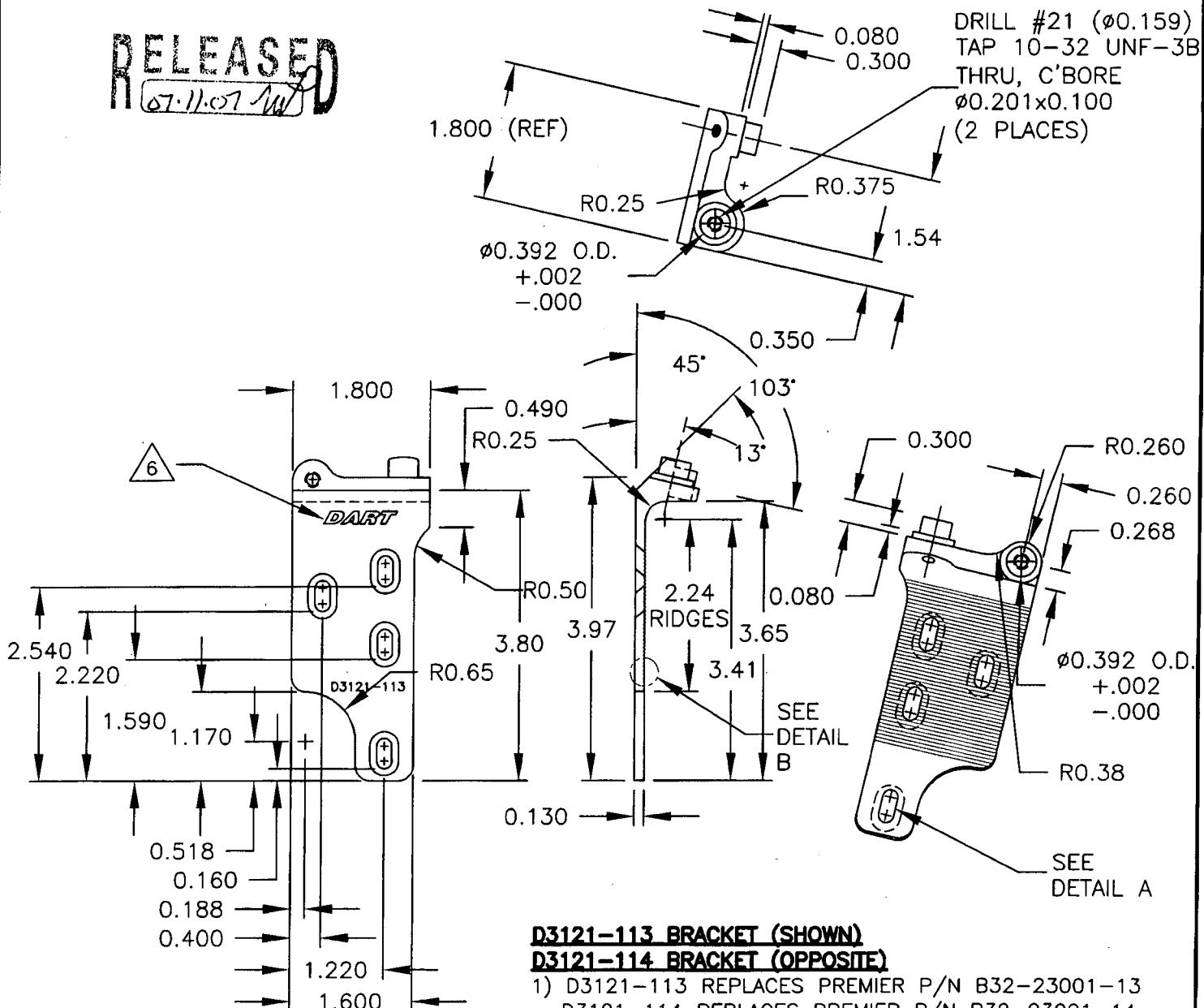
**RELEASED**  
*(07.11.07/MW)***D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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		D3121	SHEET 8 OF 10
DATE	TITLE	SCALE	1:2
07.11.07	BRACKET ASSEMBLY		

**RELEASED**  
*(07.11.07 MWD)***D3121-113 BRACKET (SHOWN)****D3121-114 BRACKET (OPPOSITE)**

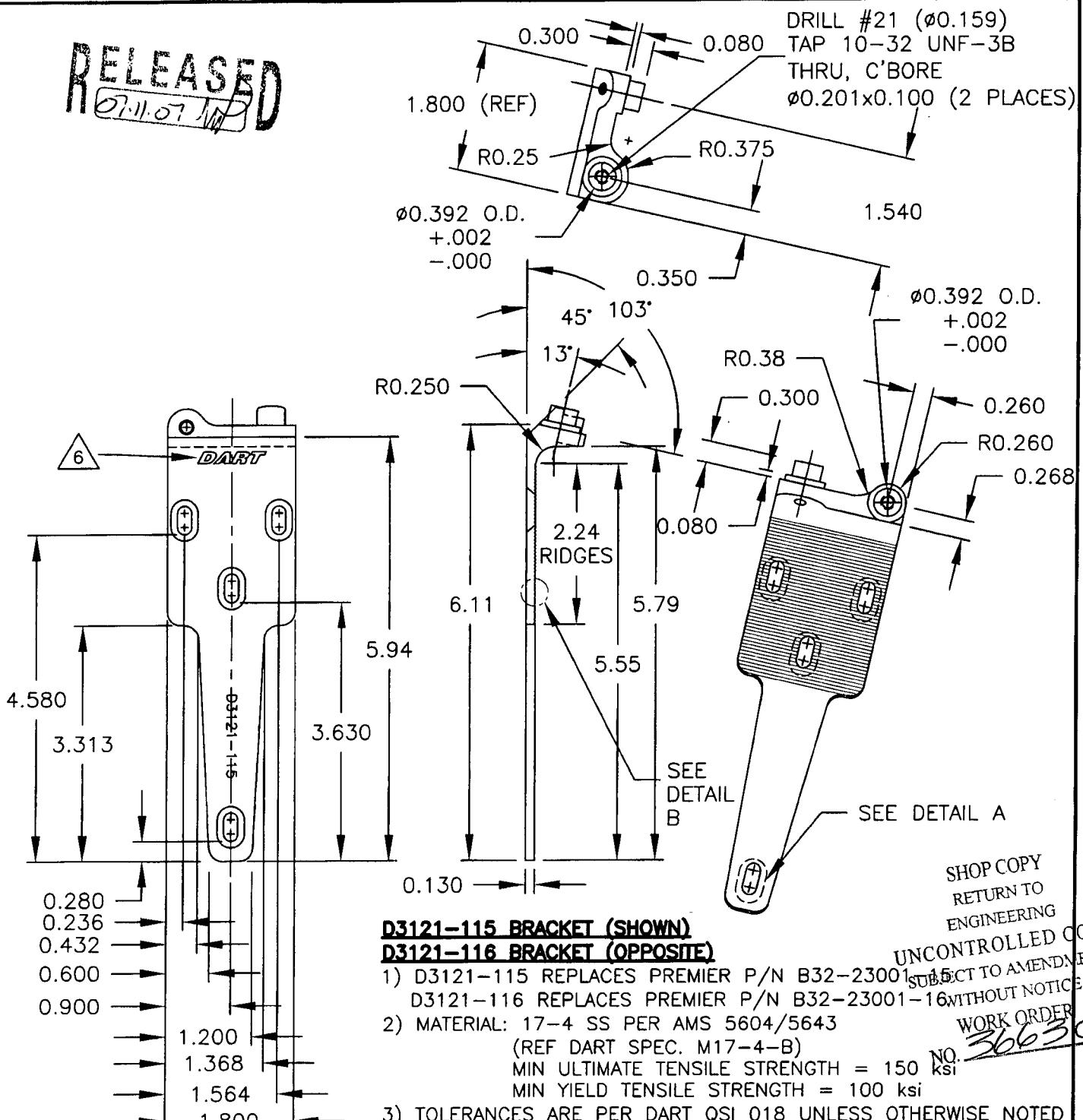
- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 SHOP COPY  
(REF DART SPEC. M17-4-B) RETURN TO  
MIN ULTIMATE TENSILE STRENGTH ~~ENCL~~ <sup>100 KSI</sup> ENGINEERING  
MIN YIELD TENSILE STRENGTH ~~ENCL~~ <sup>100 KSI</sup> SILLED COPY
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED <sup>UNCONTOLLED COPY</sup> SUBJECT TO AMENDMENT  
WITHOUT NOTICE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN <sup>WORK ORDER</sup> *36630*
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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CHECKED	APPROVED	DRAWING NO. D3121
DATE		REV. E SHEET 9 OF 10 TITLE SCALE BRACKET ASSEMBLY 1:2
07.11.07		

**RELEASED**  
*07.11.07 WD*

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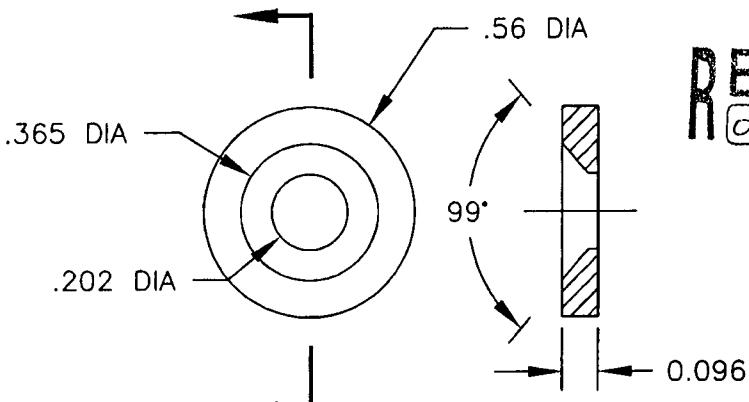
- 1) D3121-115 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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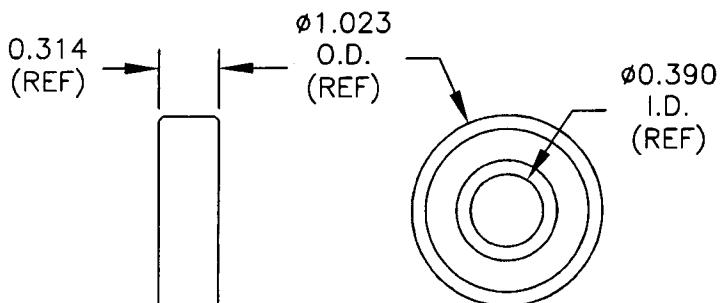
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**DART**

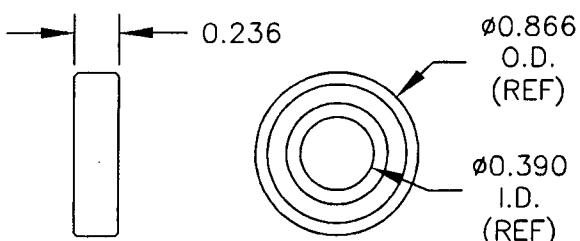
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

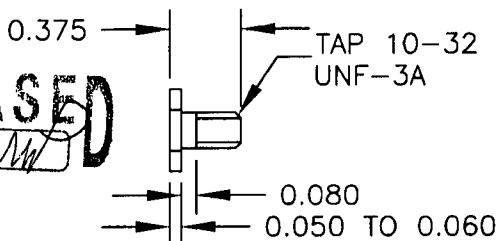
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

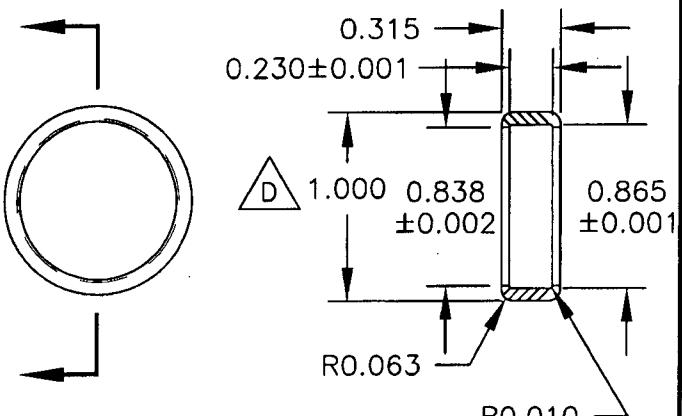
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM  
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z  
OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

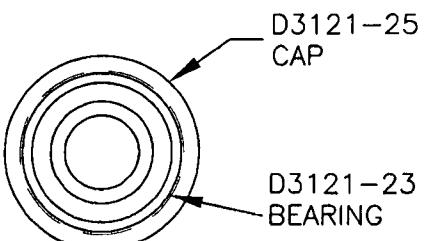
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**